



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-1BL
Job Sheet 167810-A



Part No: D2939-1BL

Job Qty: 5 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 12/12/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	5 pcs		11/23/17	0.00	0.00	QC8 Machining-1		
140	HandFinish	5 pcs		11/24/17	0.00	0.17	HandFinish1		
150	Outsource	5 pcs		11/24/17			ATE003-VC		
160	QC	5 pcs		11/24/17	0.00	0.00	QC14		
170	Packaging	5 pcs		11/24/17	0.00	0.00	Packaging3-1		
180	QC21-SA	5 Ea		11/24/17	0.00	0.00	QC21		

Part Op 150 - ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO
Descriptions:

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Printed 12/12/17 9:23 AM dart.lacelle.linda

not painted Blue

See job # 172418

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-1BL
Job Sheet 167810



split
(5)

Part No: D2939-1BL

Job Qty: 10 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/23/17	0.00	0.00	Start Up Machining		FK 17-12-2
100	CNC Vertical Machining	10 pcs		11/23/17	0.54	14.08	HAAS 1		FK 17-12-3
110	Mill Conv	10 pcs		11/23/17	0.00	0.00	Mill Conv 1		FK 17-12-3
120	QC	10 pcs		11/23/17	0.00	0.00	QC1		FK 17-12-3
130	QC	10 pcs		11/23/17	0.00	0.00	QC8		
140	HandFinish	10 pcs		11/23/17	0.00	0.34	HandFinish1		
150	SprayPaint	10 pcs		11/24/17	0.00	1.03	Spray Paint		
160	QC	10 pcs		11/24/17	0.00	0.00	QC14		
170	Packaging	10 pcs		11/24/17	0.00	0.00	Packaging3		
180	QC21-SA	10 Ea		11/24/17	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0
F-164403 (5016547)					

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:24 AM dart.Michaud-Febrille.Victoria

DART AEROSPACE LTD	Work Order:	163810
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.115	.116	.116	.115		
B	0.100	0.140		.114	.114	.113	.114		
C	0.100	0.140		.117	.118	.117	.117		
D	0.210	0.230		.224	.225	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.237	.238	.237	.237		
N	0.100	0.140		.121	.121	.121	.121		
O	0.540	0.560		.549	.548	.548	.549		
P	0.490	0.510		.500	.501	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.741	2.742	2.742	2.743		
S	0.240	0.270		.255	.255	.255	.254		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by: <u>FK</u>
Date: <u>17-12-2</u>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order:	167810
Description: 206 Saddle, Inboard, Left side		Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.115	.113	.115	.115		
B	0.100	0.140		.114	.116	.112	.113		
C	0.100	0.140		.119	.118	.117	.117		
D	0.210	0.230		.224	.224	.223	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.573	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.237	.236		
N	0.100	0.140		.121	.121	.120	.121		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.500	.500	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.743	2.743	2.743	2.744		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	F.R.
Date:	17-12-2

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order:	167816
Description: 206 Saddle, Inboard, Left side		Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	3	4		
A	0.100	0.140		.115	.115				
B	0.100	0.140		.113	.113				
C	0.100	0.140		.118	.117				
D	0.210	0.230		.228	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.237	.238				
N	0.100	0.140		.121	.121				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.744	2.744				
S	0.240	0.270		.255	.254				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/				

Measured by: FK	Audited by:
Date: 17-12-3	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	